

Work Order ID 142085

Wednesday, February 24, 2016 11:26:04 AM

142085

U/R

Page 1

Item ID: D412-664-403 Accept *N900040100* Setup Start *NS1*
Revision ID: URF 15-561 Stop *NS2*
Item Name: 412 Stainless Steel Aft Crosstubes - High
Start Date: 3/21/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 2/24/2016 Req'd Qty: 1.00 *1* Customer:
Reference: 4/08/2016

Approvals: Process Plan: MLJ Date: FEB 24 2016 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-664-443	A U/R <u>OK</u> <u>CP 16/3/15</u>	<u>DAS</u> 0.00						<u>DAS</u> 21 9-89	<u>16-05-02</u>
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00						<u>1</u> <u>DAS</u> 28 9-89	<u>OCT 11 2016</u>
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD412-664-403		CHG001						
110	BENDING MACHINE - CROSSTUBES	0.00							
110									
CNC Bend 2	Memo	0.03							<u>BL</u> <u>16/03/28</u>
CNC Alpha 160 Bender	Bend tube as per Dwg D412-664-443 using CNC bender program <u>N/A</u> and Folio FT <u>N/A</u>								
	****USE (4) DT9824 SHIM BLOC TO CHECK STRAIGHTNESS****								
127	QC15- Crosstube Dimensional Check	0.00							
127									
QC	Memo	0.00							<u>1</u> <u>Ø</u> <u>DAS</u> 49 9-89
Quality Control	***MARK CUT LINES***								<u>16/03/29</u>

D412-664-403/142085

Wednesday, February 24, 2016 11:26:04 AM

Page 2

4-Remove all marks from tube within limits of D412-664-43 DWG.

Wednesday, February 24, 2016 11:26:04 AM

Page 3

Reference:

Stop *NR2*

[illegible]

Work Order ID 142085

Wednesday, February 24, 2016 11:26:04 AM

142085

Page 5

Item ID: D412-664-403 **Accept** ***N900040100*** **Setup** **Start** ***NS1***
Revision ID: URF 15-561 **Stop** ***NS2***
Item Name: 412 Stainless Steel Aft Crosstubes - High
Start Date: 2/24/2016 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 3/11/2016 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC14- Inspect Spray Paint	0.00							
190									
QC	Memo	0.00							
Quality Control									

1610-06

Work Order ID 142085

Wednesday, February 24, 2016 11:26:04 AM

142085

Page 6

Item ID: D412-664-403 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-561 Stop ***NS2***
Item Name: 412 Stainless Steel Aft Crosstubes - High
Start Date: 2/24/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/11/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

2000

Crosstubes

Crosstubes

Crosstubes

Memo

1- Install center support using scoth-weld DP460 per QSI 015, as per DWG. note 12. Install supports clamps using as per Dwg D412-644-443. Install clamp with rubber cushion as per DWG. note 13. ***ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT*** Torque clamps on support to 80-100 IN-LBS AS PER DWG.

A/R scoth-weld DP460 BATCH #: 134469
EXP DATE: 4/17

2- **IF NOT ALREADY PRESENT ON CHAFFING SHEILD.** Apply a thin coat of proseal 890 per QSI 015 on inside concave surface of chafing shield and let cure per manufacturer's instructions. Install prosealed chafing shield onto crosstube by applying a thin coat of proseal 890 onto crosstube. Be sure to eliminate any air gaps. Install and torque clamps on chafing shield to 40-50 IN-LBS AS PER DWG.

A/R Proseal 890 Batch: 135390
EXP DATE: 12/16

AFTER FINISH CURE TIME 24H

START CURE TIME: 16-10-6FINISH CURE TIME: 16-10-7

PRIOR TO PACKAGING RE-CHECK TORQUE ON CLAMPS AFTER
CURED FOR 24H.

DAS

41

9-89

16-10-6

Work Order ID 142085

Wednesday, February 24, 2016 11:26:04 AM

142085

Page 7

Item ID: D412-664-403 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-561 Stop ***NS2***
Item Name: 412 Stainless Steel Aft Crosstubes - High
Start Date: 2/24/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/11/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo PRIOR TO PACKAGING RE-CHECK TORQUE ON CLAMPS AFTER CURED FOR 24H.	0.00 0.00				1			
220 *220* Packaging Packaging	Pick Kit Memo	0.00 0.00				1			
230 *230* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				1			

Work Order ID 142085

Wednesday, February 24, 2016 11:26:04 AM

142085

Page 8

Item ID: D412-664-403 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: URF 15-561 **Stop** ***NS2***
Item Name: 412 Stainless Steel Aft Crosstubes - High
Start Date: 2/24/2016 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 3/11/2016 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00				1	DAS 27 9-89	DAS 28 9-89	OCT 11 2016
240	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPPD412-664-443 Location: _____ PPP Rev: _____								
250	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		OCT 11 2016
250	QC	0.00							
Quality Control	Memo								

DAS
21
9-89
OCT 11 2016

Picklist Print

Wednesday, February 24, 2016 11:26:07 AM

Page 1

Work Order ID: 142085

142085

Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-664-443TRN		Manufactured	No			110	Each	4.0000	1	1			
D412-664-443TRN									**	1	1	BL 16/03/28	
Crosstube Turning Detail													

Location	Loc Qty	Loc Code
LG003	4	
139897	1	
139898	1	
139899	1	
139900	1	

D3595-063-530

Manufactured No

200

Each

38.0000

2

2

DAS
41
9-89

16-10-6

D3595-063-530

Rubber Cushion 0.63" wide x 5.30" Long

Location	Loc Qty	Loc Code
FG	1	
82656	1	
LG051	1	
132515	1	
LG052	36	
138921	36	

D4909-1

Manufactured No

200

Each

9.0000

1

1

DAS
41
9-89

16-10-6

D4909-1

Support

Location	Loc Qty	Loc Code
LG053	9	
135507	5	
140154	4	

Picklist Print

Wednesday, February 24, 2016 11:26:07 AM

Page 2

Work Order ID: 142085

142085

Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

D4910-1

Manufactured No

200

Each

17.0000

2

2

D4910-1

Chaffing Shield

**

DAS
41
9-89

16-10-6

Location

Loc Qty

Loc Code

LG053

17

139520

8

141315

9

MS21920-26

Purchased No

200

Each

27.0000

4

4

MS21920-26

Clamp

**

DAS
41
9-89

16-10-6

Location

Loc Qty

Loc Code

LG057

27

M132045

1

M133234

2

M133483

4

M133577

20

MS21920-28

Purchased No

200

Each

92.0000

2

2

MS21920-28

Clamp

**

DAS
41
9-89

16-10-6

Location

Loc Qty

Loc Code

FG

1

105884

1

LG051

1

M132169

1

LG057

90

M130400

50

M133090

2

M134130

38

Picklist Print

Wednesday, February 24, 2016 11:26:07 AM

Page 3

Work Order ID: 142085

142085

Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

AN6-40A

Purchased

No

220

Each

66.0000

4

4

AN6-40A

3/8-24 BOLT X 3" LONG

DAS
28
9-89

Location

Loc Qty

Loc Code

over005

24

M133316

24

ST333

42

M133769

42

**

DAS
6
9-89

DAS
27
9-89

AN6-41A

Purchased

No

220

Each

35.0000

2

2

AN6-41A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

over005

25

M133577

25

ST286A

1

M129913

1

ST333

9

M131957

9

**

DAS
6
9-89

DAS
27
9-89

AN960JD616

NAS1149D0663J

Purchased

No

220

Each

0.0000

18

18

AN960JD616

Washer

DAS
28
9-89

**

DAS
6
9-89

DAS
27
9-89

APR 30 2016

Picklist Print

Wednesday, February 24, 2016 11:26:07 AM

Page 4

Work Order ID: 142085

142085

Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

220

Each

208.0000

6

6

MS21042L6

Nut

DAS
6
9-89

DAS
27
9-89

APR 30 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

ST007

100

m134055

100

ST303

108

m133134

5

m133932

3

m133938

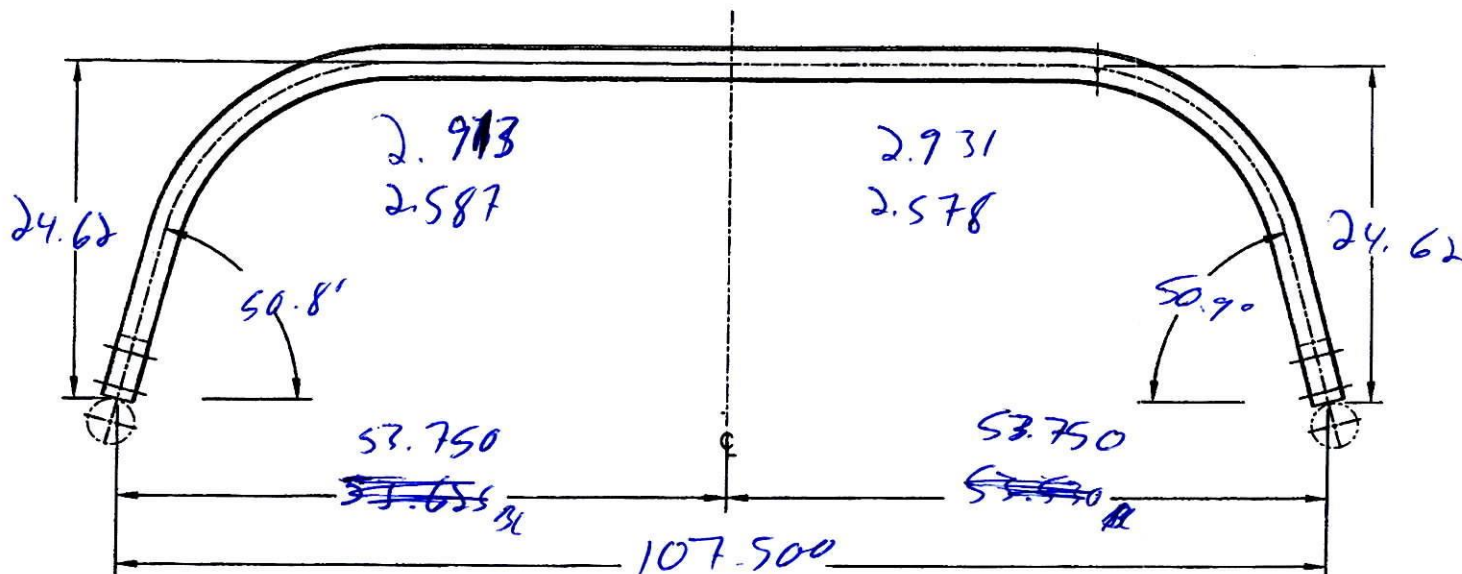
50

m134257

50

DART AEROSPACE LTD		Work Order:	142085
Description: Crosstube High Aft (412)		Part Number:	D412-664-403
Inspection Dwg: D412-664-443 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	24.12	24.62
1/2 Span	53.56	53.82
Angle	49°	52°
Total Span	107.12	107.64
Bending Passes	8	--
Crushing	--	7%



	Side A	Side B
Bending Passes	4	4
Crushing	5.9%	6.4%
Comments		

QC15 Inspection	DAS
Date	49
	9-89

16/03/29

Rev	Date	Change	Revised by	Approved
A	14.07.08	New Issue	KJ	UP

Item	Qty -443	Part Number	Description
1	X	D412-664-443	CROSSTUBE ASSEMBLY (412 HI AFT)
2	1	D6020-132	CROSSTUBE MATERIAL (132" MIN. LENGTH)
3	2	D3595-063-530	RUBBER CUSHION
4	1	D4909-1	SUPPORT
5	2	D4910-1	CHAFING SHIELD
7	4	MS21920-26	CLAMP
8	2	MS21920-28	CLAMP
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD
10	A/R	PROSEAL 890	SEALANT

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6020-132
FINISHED LENGTH = 130.10±0.060 (BEFORE BENDING/TRIMMING)
 - 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2, HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, REMOVE MASKING AND APPLY MATTE CLEAR COAT PER DART QSI 005 4.2
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 - 6) IDENTIFICATION: SCRIBE DART P/N "D412-664-443" AND B/N ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
 - 7) WEIGHT: 90.2 lb AFTER MACHINING
88.7 lb FINISHED WEIGHT
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE.
 - 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- BENDING**
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7% (BASED ON O.D.) IN LOWER HALF OF R35 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
 - 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.

ASSEMBLY

- 12) INSTALL D4909-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015.
- 13) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D4909-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT.
- 14) IF NOT ALREADY PRESENT ON CHAFING SHIELD, APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D4910-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEALED D4910-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.
- 15) TORQUE CLAMPS ON D4909-1 SUPPORT 80 TO 100 IN-LB. TORQUE CLAMPS ON D4910-1 CHAFING SHIELD 40 TO 50 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVES HAVE CURED FOR 24 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 142085 MJS
16-02-24

UNDER REVIEW

4/15/19
LRF 15-561

UNDER REVIEW

4/17/19
LRF 15-561

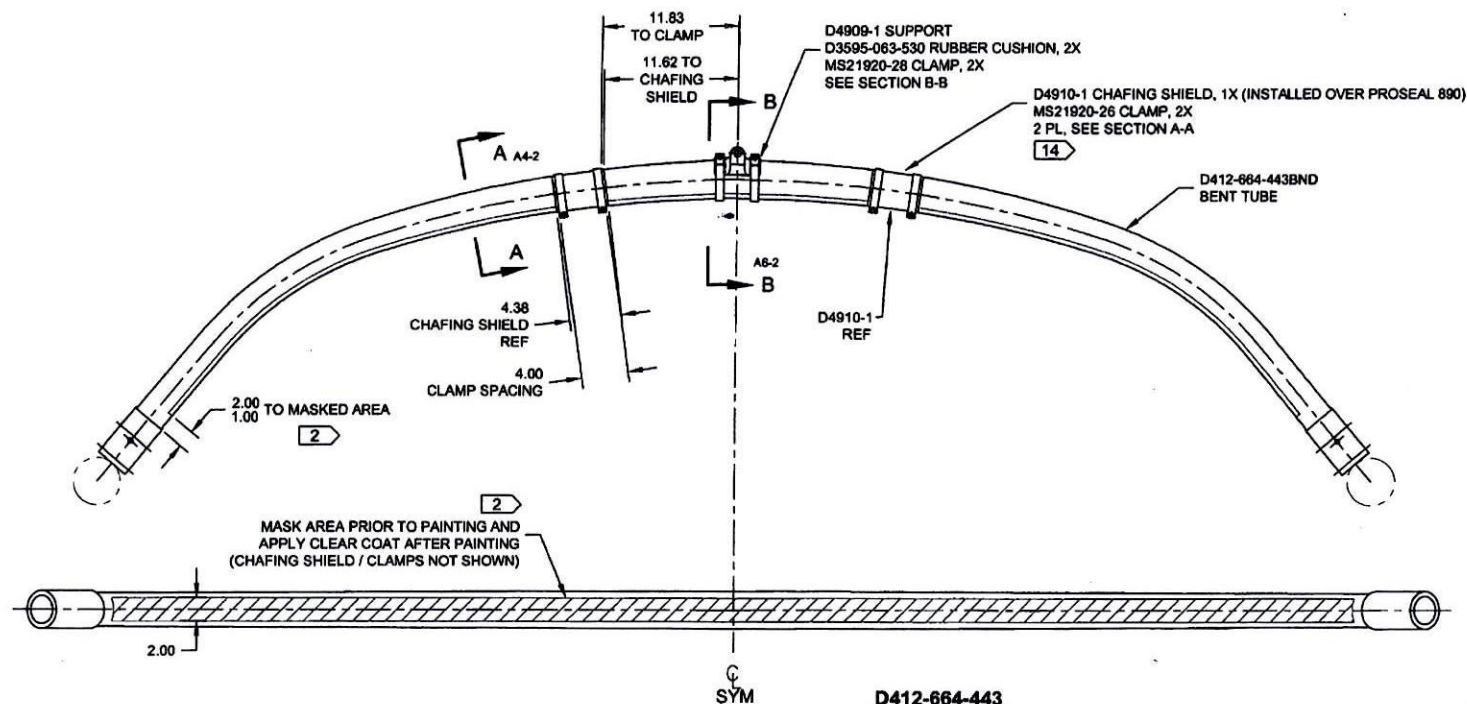
RELEASED
2014-05-26
WJD

A	NEW ISSUE	CP	14.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	JP		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D412-664-443 SHEET 1 OF 4
TITLE SCALE
CROSSTUBE ASSY (412 HI AFT) NTS

COPYRIGHT © 2013 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



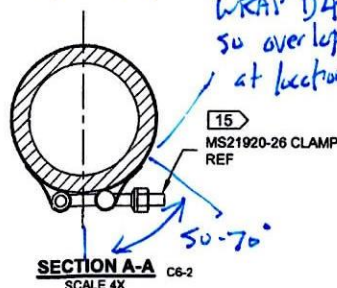
D412-664-443
ASSEMBLY DETAIL

APPLY 3M SCOTCH-WELD DP460
BETWEEN D4909-1 SUPPORT AND
THE CROSSTUBE

D4909-1
SUPPORT
REF

D3595-063-530
RUBBER CUSHION
UNDER CLAMP, REF

SECTION B-B
SCALE 4X



SECTION A-A
SCALE 4X

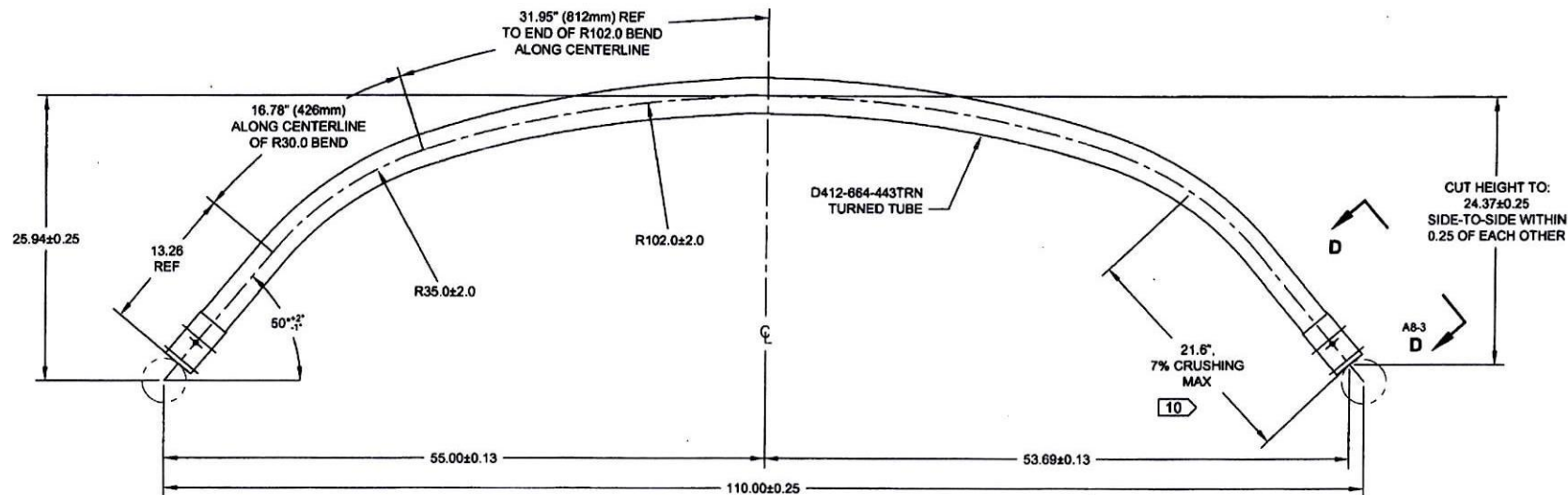
UNDER REVIEW

15/4/28

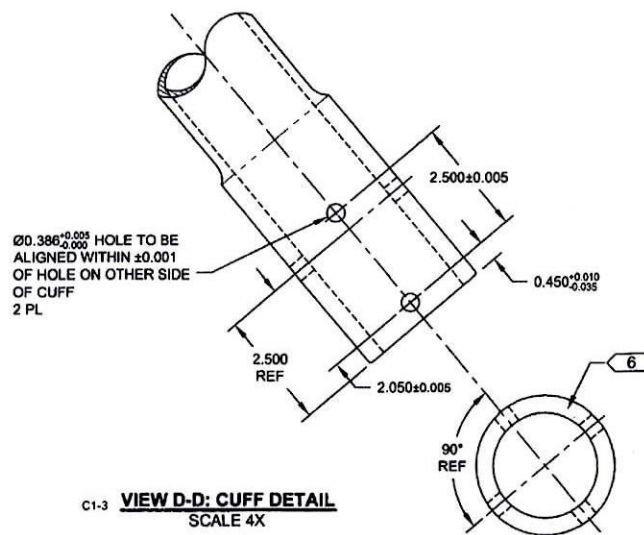
UNDER REVIEW

RELEASED
2014-05-26

DESIGN	<i>JP</i>	DART AEROSPACE LTD	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JP</i>	D412-664-443	SHEET 2 OF 4
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	CROSSTUBE ASSY (412 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D412-664-443BND 10
BENDING DETAIL



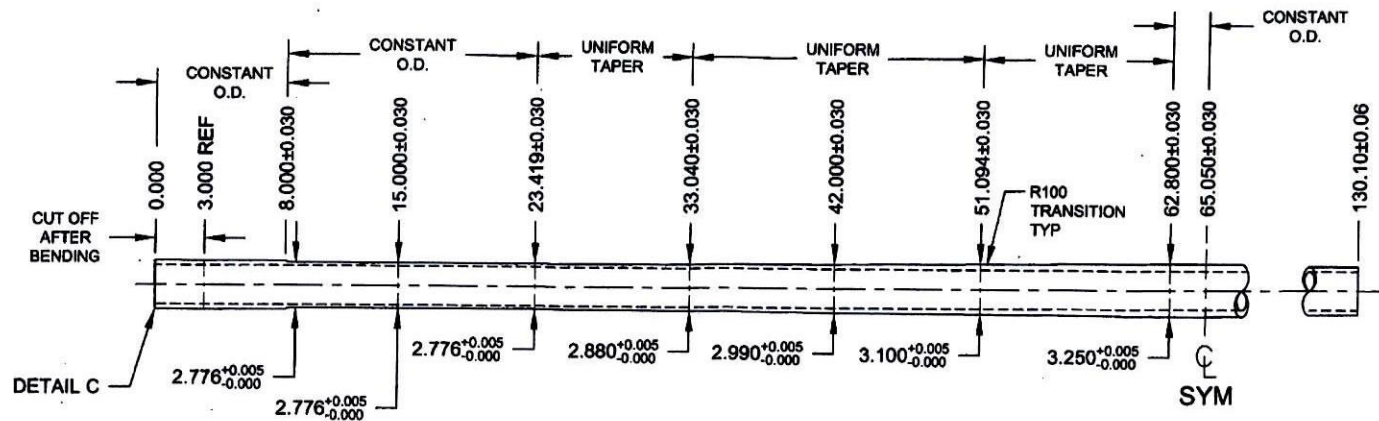
C-1-3 **VIEW D-D: CUFF DETAIL**
SCALE 4X

OK **UNDER REVIEW**
11/7/36

UNDER REVIEW
15/9/20

RELEASED
2014 -05- 26

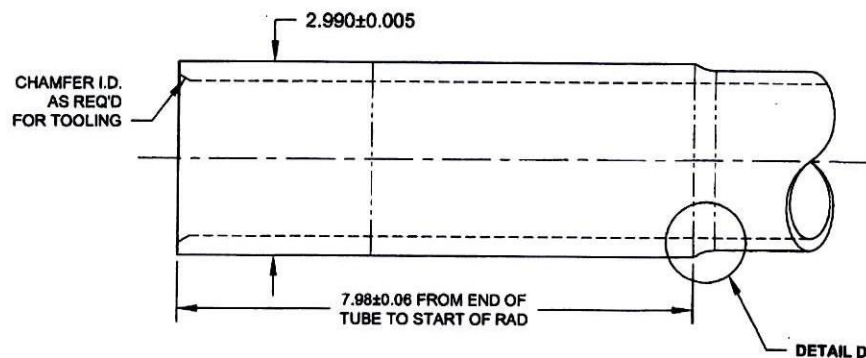
DESIGN	QP	DART AEROSPACE LTD	
DRAWN	QP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.	BA	D412-664-443	SHEET 3 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASSY (412 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



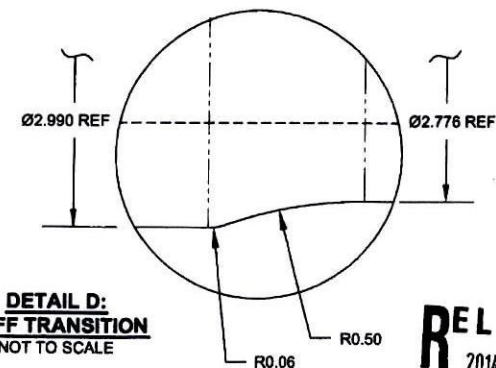
D412-664-443TRN
TURNING DETAIL

UNDER REVIEW

15/4/28



DETAIL C:
CUFF TRANSITION
SCALE 4X



DETAIL D:
CUFF TRANSITION
NOT TO SCALE

RELEASED
2014-05-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D412-664-443	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31971**

Purchase Order Date 4/7/2016
PO Print Date 4/11/2016

Page Number 2 of 4

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Total: \$135.00

3	143855	D412-664-203 CROSSTUBE	4/11/2016	1.00	\$135.00	\$135.00
---	--------	---------------------------	-----------	------	----------	----------

Yes
4/11/2016

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$135.00

4	143856	D412-664-203 CROSSTUBE	4/11/2016	1.00	\$135.00	\$135.00
---	--------	---------------------------	-----------	------	----------	----------

Yes
4/11/2016

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$135.00

5	142085	D412-664-403 CROSSTUBE	4/11/2016	1.00	\$135.00	\$135.00
---	--------	---------------------------	-----------	------	----------	----------

Yes
4/11/2016

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

8/16-04-12

Note:

4/11/2016

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO27855	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO31971
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING seven (7) CROSSTUBES:

ID# D412-664-403 STAINLESS STEEL AFT CROSSTUBES-HIGH

1 WORK ORDER ID 142085 2-WORK ORDER ID 142086
3-WORK ORDER ID 142087 4-WORK ORDER ID 143893

ID# D412-664-203 AFT CROSSTUBES-HIGH

5 WORK ORDER ID 143853 6 WORK ORDER ID 143855
7 WORK ORDER ID 143856

SP/6-04-12

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-7) AS PER ASTM1417 M-13						11 APR 20/6	
NO APPARENT DEFECT FOUND							
PEN.(ZL-56, MPO13600), DEV.(SKD-S2, MPO11715), CLEANER(SKC-S, MPO13923)							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: 11 APR 20/6
Name: CHRISTIAN BRIEN		